

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008742**Date Inspected:** 04-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1330**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Chung Fu Kuan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

On this date, 8/04/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on cast sections and associated built up plate sections in the Fabrication shop #4 at Japan Steel Works (JSW), Muroran, Japan.

**WEST DEVIATION SADDLES**

W2E2 - Observed completed saddle section as having had an MT/VT verification done to the saddle trough.

W2W2 - Saddle section is blasted and waiting Final PWHT NDE.

W2W3 - Grinding of completed welds by M.Kato and M.Kashiwada was observed at the end of C shift. Saddle section will required repositioning to continue welding of plate portion to cast.

**TOWER SADDLES**

T1-3 - JSW employee Y.Ohta was in process tack welding stiffener plates 9ST-22, -23, -24 in place to complete fitup. The following welders were running root passes to 9ST-19, -20, -21; M.Yamashita 73-4195, S.Watanabe 08-5159, T.Ohkawa 03-3091 respectively, and CWI Mr. Chung Fu Kuan reviewed their process to verify the parameters were per SJ-3012-8-1 randomly. All were using SMAW process, 4mm E7016 electrode, per SJ-3012-8-1. Mr. R.Kumagai #132 of NIS staff was performing dry powder MT of root passes as need arises.

**EAST SADDLES**

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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E2E1 - Cast section is having excess reinforcement on repairs ground, per JSW representative Mr. Hideaki Kon, in the weld pit in Foundry, the NDE of the repair welding will then commence.

E2W1 - Idle. Now located in Fabrication Shop #4.

West Jacking Saddle - Located in the Foundry, remaining NDE of shaped/dressed surface of casting being completed.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

### Summary of Conversations:

No significant conversations to report on this day.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Brcic,Michael	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

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